

**IN THE CLAIMS**

Claim 17 has been amended. Claims 23 to 28 have been canceled. This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

Claims 1 to 16 (canceled).

Claim 17 (currently amended): A method for manufacturing a foamed polyurethane molded article, the method comprising:

- introducing an expandable polyurethane reactive mixture into a mold and evacuating the mold, the mold having a top mold region;
- expanding the reactive mixture ~~expands~~ so as to fill the mold;
- exhausting gases liberated during the expanding step through one or more expansion openings disposed at one or more points of maximum height in the top mold half, each of the expansion openings being closeable by a needle valve disposed in a valve capillary;
- sensing a temporal pressure characteristic in the valve capillary;
- controlling each of the one or more needle valves using the temporal pressure characteristic, so as to close the respective expansion opening in response to a pressure drop occurring when the expanding reactive mixture penetrates into the valve capillary;
- opening the mold; and
- ejecting the molded article.

Claim 18 (previously presented): The method as recited in claim 17, wherein the evacuating of the mold is performed using the one or more the needle valves.

Claim 19 (previously presented): The method as recited in claim 17, wherein the introducing step is also performed using the needle valves.

Claim 20 (previously presented): The method as recited in claim 17, wherein the ejecting of the molded article is performed using the needle valves to act upon the mold with compressed air.

Claim 21 (previously presented): The method as recited in claim 17, wherein each of the one or more needle valves is supplied with at least one of negative pressure and compressed air from a shared media supply.

Claim 22 (previously presented): The method as recited in claim 17, wherein the one or more needle valves includes a plurality of needle valves and further comprising adjusting a negative pressure to each of the needle valves individually.

Claim 23 to 28 (canceled).